

Work Order ID 164243-2

Monday, July 17, 2017 1:58:42 PM

164243

Page 1

Item ID: D2680-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Nut Plate

Start Date: 8/4/2017

Start Qty: 40.00

40

Cust Item ID:

Required Date: 9/25/2017

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date: JUL 17 2017

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2680

Rev B1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.69

FLOW CNC Waterjet

1-Cut as per Dwg D2680 Dwg Rev: B1 Prog Rev: B1 2-
Debur if necessary

(40)

07/17/2017

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.40

Quality Control

(40)

07/17/2017

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.80

Quality Control

40

 DAS
 38
 9-89
 JUL 24 2017

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Item ID: D2680-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate
 Start Date: 8/4/2017 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 9/25/2017 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					40x			17/07/25
Small Fab	Memo	1.06							DAS 36 9-89
Small Fab	1- Deburr 2-C'sink as per Dwg D2680								
140		0.00							
140	QC5- Inspect part completeness to step on W/O					40			DAS 36 9-89
QC	Memo	0.80							JUL 25 2017
Quality Control									
145		0.00							
145	SprayPaint								
Spray Painting	Memo	0.00							20 0170727
	PRIME B								DAS 34 9-89
	DEFLEET BLUE B								
	DEFLEET CLEAR B								

*1380H.
 Powder coat white gloss
 per DSICOS*

*START: 10:40.
 OV. T: 4000
 FINISH: 11:10.*

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Item ID: D2680-041 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Nut Plate
Start Date: 8/4/2017 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
151 *151* QC Quality Control	QC14- Inspect Spray Paint <i>QC3</i> Memo	0.00 0.00			DAS 30 9-89	<u>20</u>	<u>Ø</u>		JUL 26 2017
170 *170* Small Fab Small Fab	Small Fab Memo Install Nut Plate as per Dwg D2680	0.00 0.51				<u>20</u>	<u>Ø</u>	JUL 27 2017	DAS 19 9-89
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.80				<u>20</u>		JUL 27 2017	DAS 38 9-89

101

101
102
103

101 102 103

101 102 103

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Item ID: D2680-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Nut Plate

Start Date: 8/4/2017 Start Qty: 40.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>FR001</u> Memo LOCATION :LG001	0.00 0.40				<u>x20</u>	<u>d</u>	<u>ell</u>	<u>WLCZLZ</u>
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 4.00							<u>17/7/31</u> <u>df</u>

DAS
21
9-89

JUL 27 2017

Picklist Print

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Work Order ID: 164243

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Parent Item: D2680-041

D2680-041

Parent Item Name: Nut Plate

Start Date: 8/4/2017

Required Date: 9/25/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: D04.10.01Added Steps 2-4, 7-8KJ/JLM
IPP Rev:E Now on WaterJet 06-10-12 JLM
IPP rev F QC5 after c'sink 07.07.05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21069L4 *MS21069L 4* Nut Plate		Purchased	No			110	Each	101.0000	1	40		JUL 27 2017	DAS 19 9-89

Location Loc Qty Loc Code

ST299 101
m137459 1
m137710 100

M1010S16GA
M1010S16GA
1010/1025 sheet 16GA

Purchased No 170 sf 75.0509 0.0131 0.551579

Location Loc Qty Loc Code

MAT019 75.050947
124428 75.050947

MS20426AD3-3
MS20426AD3-3
RIVET

Purchased No 170 Each 2,047.000 2 80

Location Loc Qty Loc Code

FG107/108 80
M137350 80
fg108 200
M134946 200
ST312 1767
M135274 1767

20

07/17/2017

6

40

207
13
1978

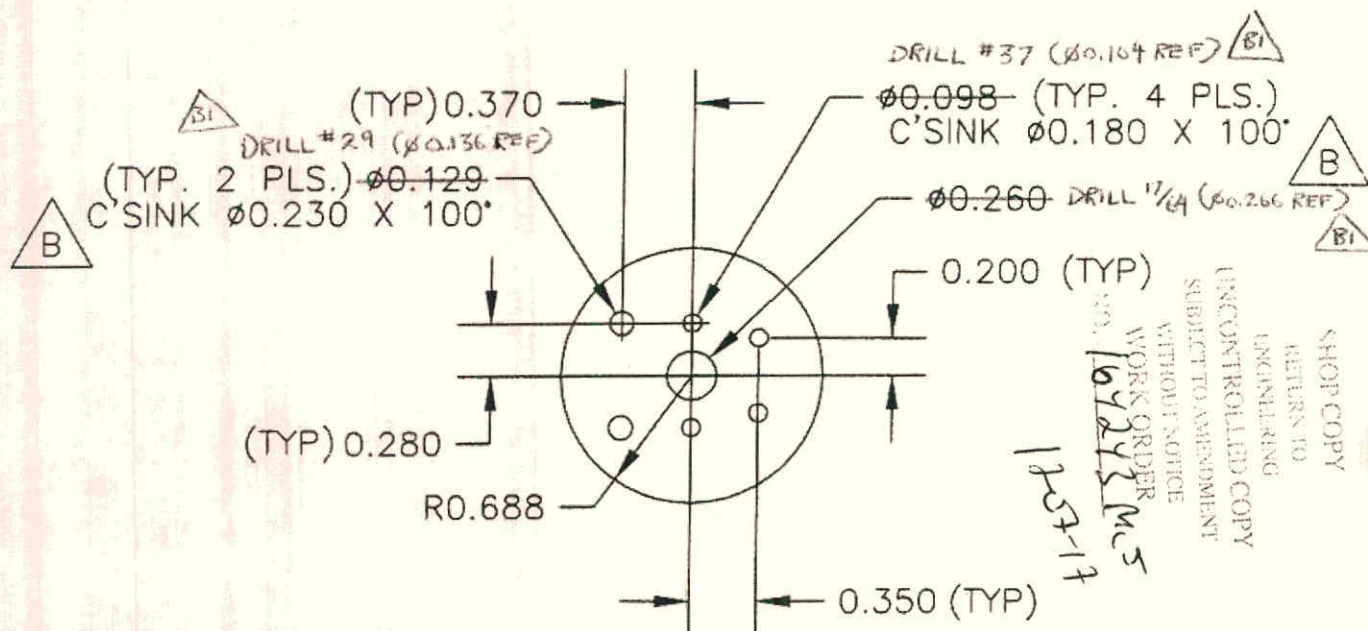
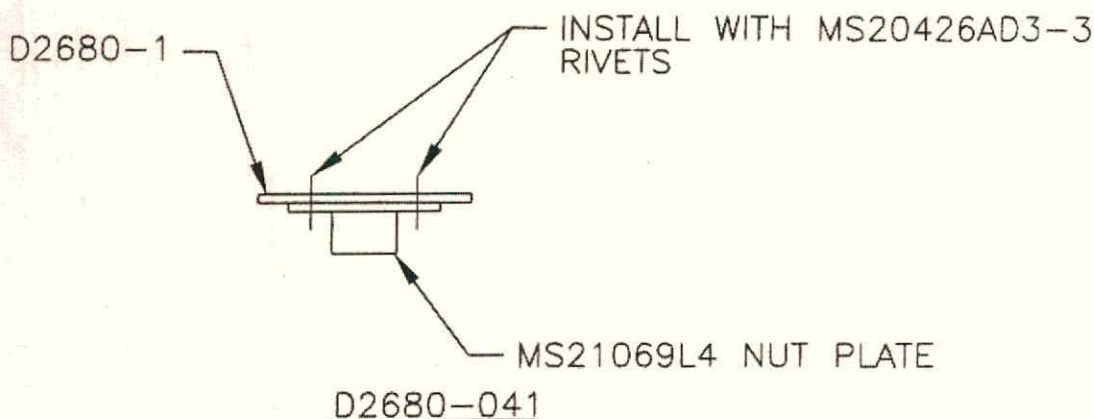
207
13
1978

1978

1978

DART

DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED CP	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14	TITLE NUT PLATE		SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
B1	CP # 04.11.04	CHANGE HOLES & FINISH	

RELEASED
98.12.14 DS

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B1 POWDER COAT WHITE (4.35.2) PER DART QSI 005 4.3
D2680-1

